

Work Order ID 112490

112490

Page 1

January-30-14 11:45:41 AM

Item ID: D206-648-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ground Handling Wheel Modification
 Start Date: 1/30/14 Start Qty: 13.00 ***13*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 13.00 ***13*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-648	Rev B	<i>SP</i>							
100		0.00							
100									
DC	Memo	0.00			DAS 06 9-89	13X			13
Document Control	Photocopy bluefile and create labels per PPP D206-648-013 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00				13X			
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00			DAS 06 9-89	13X			
Quality Control									

JUL 08 2014

DAS
26
9-89

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Required Qty: 13.00

Comments: IPP Rev:A05.09.23New issueKJ/JLM
IPP Rev:B 07-12-05 ECN 1080p DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2652 Bushing		Manufactured	No			110	Each	671.0000	8	104			DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 26 9-89
				FG		44							
				31985		44							
				ST014		627							
				103022		198							
				103642		28							
				103643		201							
				110800		200							
D3414-041 Lug		Manufactured	No			110	Each	25.0000	2				DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST445		3							
				106451		3							
				ST470		5							
				108853		5							
				ST471		17							
				108074		4							
				109539		13							
AN3C37A BOLT		Purchased	No			110	Each	127.0000	4				DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		4							
				M121068		4							
				ST353		123							
				M126345		48							
				M127823		75							

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Picklist Print

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Page 2

Work Order ID: 112490

Parent Item: D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 13.00

Required Qty: 13.00

NAS1149C0363R

Purchased

No

110

Each

1,043.0000

4

52

DAS

Washer

DAS

06

9-89

Location

Loc Qty

Loc Code

FP001

704

114742

704

ST292

339

122441

339

MS21043-3

Purchased

No

110

Each

823.0000

4

52

DAS

Nut

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

743

124555

92

m126741

651

DAS

26

9-89

DAS

31

9-89

January-30-14 11:45:40 AM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

JUL 08 2014

DAS
06
9-89

REFERENCE ONLY

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D206-648-011	GROUND HANDLING KIT
	X	D206-648-013	GROUND HANDLING KIT
8	8	D2652	BUSHING
2		D2659	GHW LUG
	2	D3414-041	LUG ASSEMBLY
4		AN3-37A	BOLT
	4	AN3C37A	BOLT
	4	AN960C10	WASHER
4		AN960JD10	WASHER
4		MS21042-3	NUT (OR MS21042L3)
	4	MS21043-3	NUT

RELEASED
09/12/16 M

B	INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE.		AJS	08.09.24
A	NEW ISSUE		JB	97.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	N/A	D206-648	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		GND HANDLING WHEEL (GHW) INSTL	NONE	
DATE	08.09.24		<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	